

Date: Tuesday, 7/11/2006 12:59:57 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH  
 Job Number : 27856  
 Estimate Number : 10266  
 P.O. Number : N/A Part Number : D350636013  
 This Issue : 7/11/2006 S.O. No. : N/A Drawing Number : D2750 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D  
 Previous Run : 27822 Material : PM  
 Due Date : 7/30/2006 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 06.07.11  
 Comment : Est Rev: H 02.09.25 Rearranged procedure steps KJ  
 est rev I 06.03.30 Per rev. D dwg EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 002

KS 06.07.17 (1)

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

826787 Pm 06-08-14 (1)

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: B 25839 BE 06-08-15 (1)

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end Pm

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8864 drilling Pm  
 holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut Pm 06-08-14 (1)  
 as per dwg D2750.

Dart Aerospace Ltd  
 W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 NOTE: Date & initial all entries  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/11/2006 12:59:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 27856

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34905

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

227834

BE 06-08-24

11.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch:

26208

BE 06-08-24

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750 .

2-Open up holes "size X" (total of 4 holes per side) as per dwg D2750

3-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5)

5-Deburr and blow out all chips from inside of tube

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

M101855

exp. date:

07-02-01

BE 06-08-23

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 5)

A/R

Aluminum Rod

batch:

M101655

BE 06-08-24

8-Grind welds flush as per Dwg D2750

BE 06-08-250

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

BE 06-08-280

10-Deburr holes

BE 06-08-250

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Date: Tuesday, 7/11/2006 12:59:58 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 27856

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

PD 06-08-30

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

A.M 06-09-05

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FC 06 09 06 (1)

16.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Wearpad

Batch: 27169-2

17.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 27074

18.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 25330

19.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 27485

W/O:		WORK ORDER CHANGES					
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Job Number: 27856

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B27862

21.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B26838

22.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B20579

23.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B229018 B28276

24.0

~~AN835A~~

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

25.0

~~AN960JD816~~

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: \_\_\_\_\_

*Remade*  
*02/11/02*

W/O:		WORK ORDER CHANGES					
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Job Number: 27856

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

M324083N8

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

Batch:

27.0

AN9803D10L

Washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch:

28.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: M101938

29.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 14522

30.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M10124

31.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M100736

32.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M102180

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 27856

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN960C10L

washer



Comment: Qty.: ~~4.0000~~ Each(s)/Unit Total : 4.0000 Each(s)

washer

Batch: 101340

34.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: m 100186

35.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: m 101537

36.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: m 100186

37.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

INSERT

Batch: 101483 x30

101715 x12

38.0

NAS1515H3L

WASHER



Comment: Qty.: ~~42.0000~~ Each(s)/Unit Total : 42.0000 Each(s)

WASHER

Batch: 101340

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: 10160187

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 27856

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

FC 06 09 06 (1)

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/09/06 (1)

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside of tube with "LPS-3" batch: m101915  
Inspect for foreign objects as per Part QSI 024

2-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m102107

EXP DATE: 02/07

3-Coat all exposed fasteners with "LPS Procyon" batch: m17168

06/10/06 (1)

43.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/10/06 (1)

44.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

45.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade

Batch: B27968 ✓

06/11/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/11/2006 12:59:59 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 27856

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M100186 ✓

47.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M100186 ✓

48.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100262 ✓

49.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M100187 ✓

50.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B27895 ✓

51.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

52.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

*Done*

*PB 06/11/01*

*P 06/11/01 (1)*

*P 6/4/01 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 73 Date: 06/11/02

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Date: Tuesday, 7/11/2006 12:59:59 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 27856

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*Handwritten signature and date: 06/11/02*

Job Completion



*Handwritten signature and date: 06/11/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



RELEASED  
dc-02-07

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27856

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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2750	REV. 0 SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED  
06.02.07

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ( $\emptyset 0.250$ -  $\emptyset 0.257$ ) FOR WEARSHOE INSERTS. C'SINK  $\emptyset 0.391 \times 100^\circ$  AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF. POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

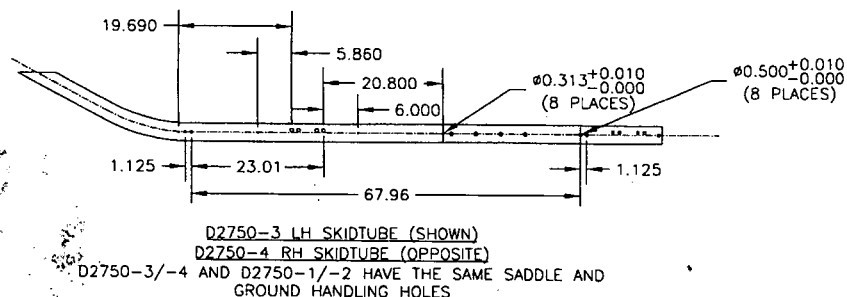
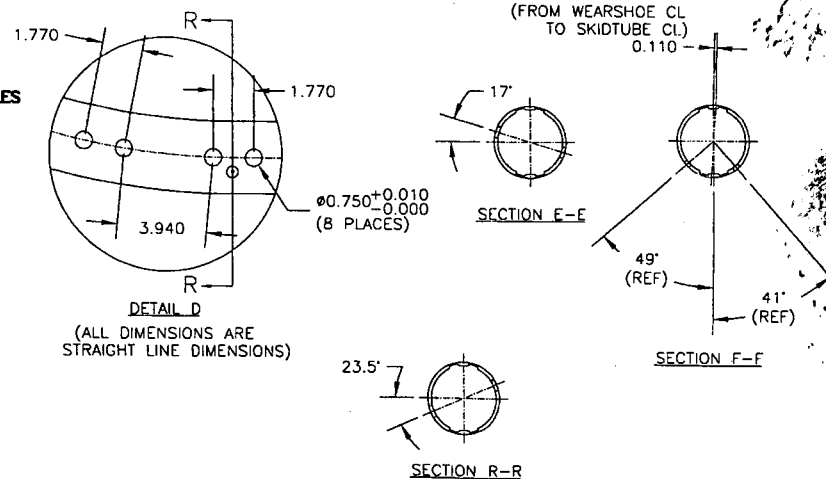
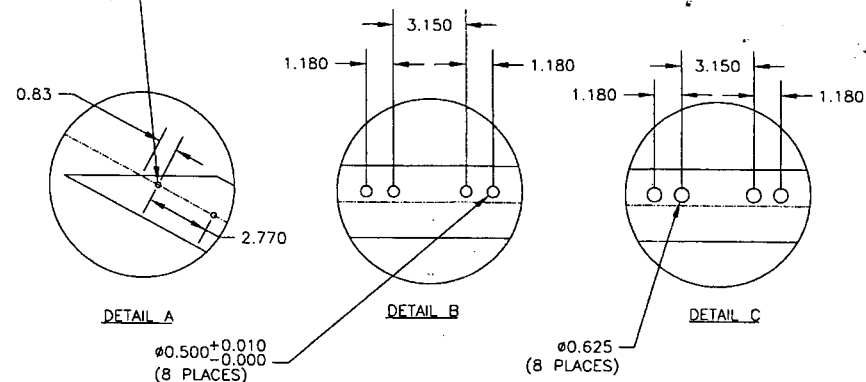
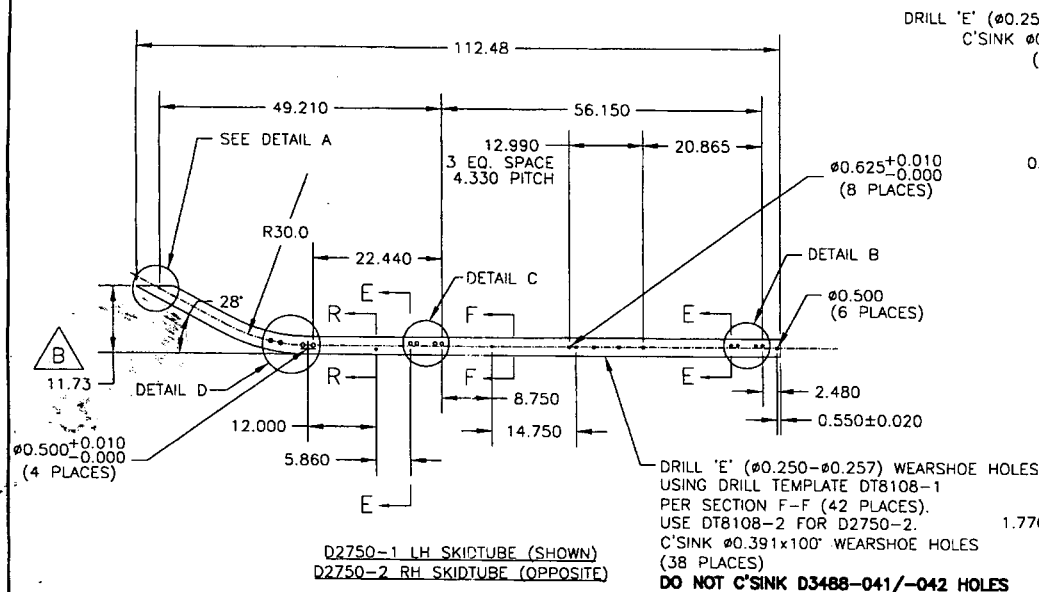
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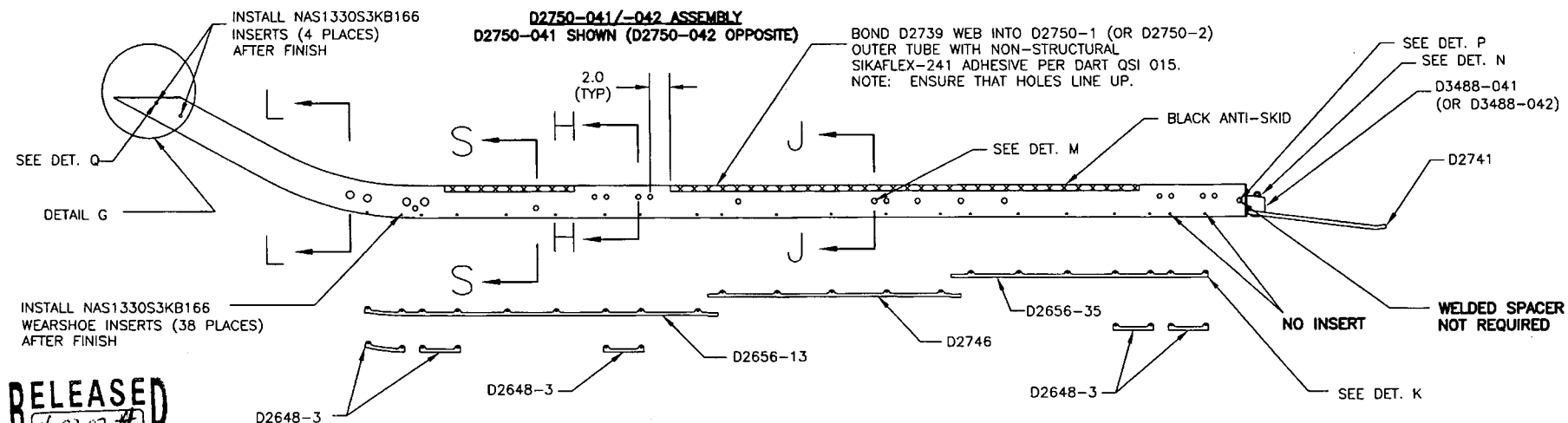
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DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY		
		REV. 0 SHEET 3 OF 5 SCALE 1:20		

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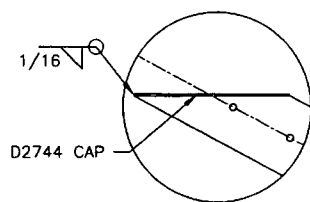
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06.02.07 #

**D2750-041/-042 ASSEMBLY**  
**D2750-041 SHOWN (D2750-042 OPPOSITE)**

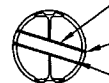
BOND D2739 WEB INTO D2750-1 (OR D2750-2)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.



**DETAIL G**

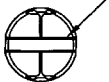


**SECTION H-H**



(TYP)

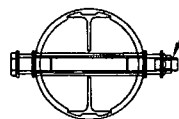
**SECTION J-J**



**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

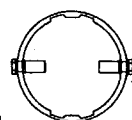
**DETAIL M**



- AN6-44A BOLT (1)  
D2745 BUSHING (2)  
NAS1515H8L WASHER (2)  
MS21043-6 NUT (1)  
(4 PLACES)

NOTE: INSTALL WASHER BETWEEN  
SKIDTUBE AND BUSHING

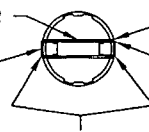
**DETAIL Q**



- AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)

**SECTION L-L**

D3490-3 SPACER

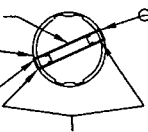


Ø0.750 HOLES ONLY

D3492-043 PLUG ASSEMBLY

**SECTION S-S**

D3490-1 SPACER



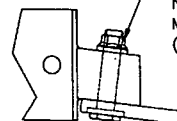
Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

**DETAIL N**



- AN8C21A BOLT (1)  
AN960JDB16L WASHER (1)  
NAS1515H8L WASHER (1)  
MS21083C8 NUT (1)  
(2 PLACES)

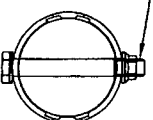
**DETAIL K**



USE AN3C7A BOLTS  
FOR INSTALLING AFT  
D2648-3 WEARPAD  
(4 PLACES)

- AN3C5A BOLT (1)  
AN960JD10L WASHER (1)  
NAS1515H3L WASHER (1)  
(38 PLACES)

**DETAIL P**



- AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

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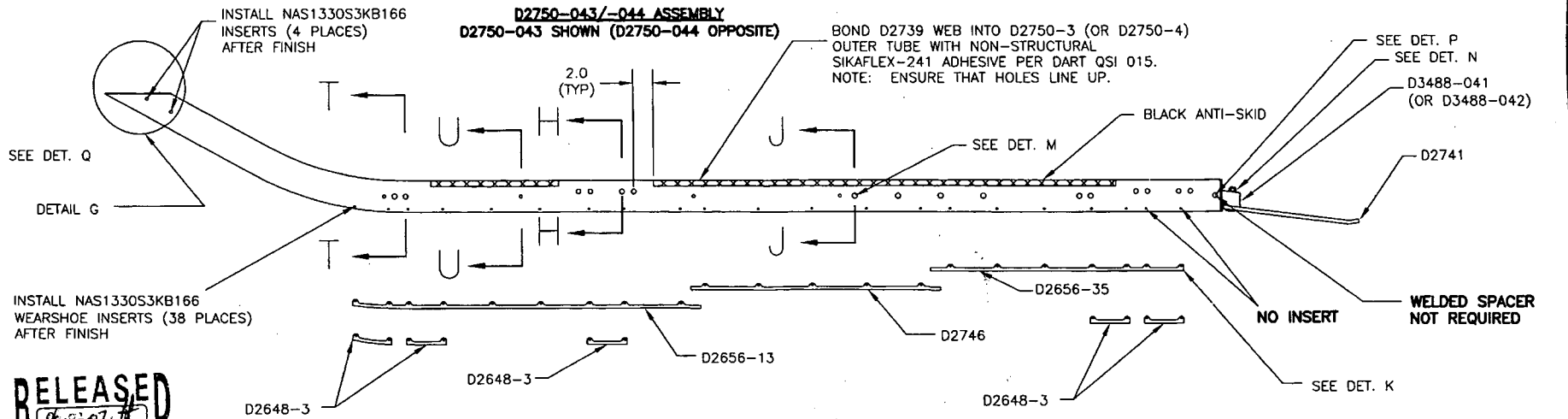
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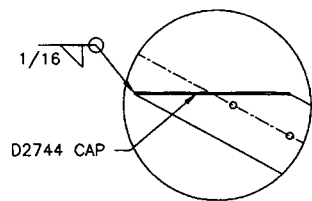
**RELEASED**  
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**D2750-043/-044 ASSEMBLY**  
**D2750-043 SHOWN (D2750-044 OPPOSITE)**

BOND D2739 WEB INTO D2750-3 (OR D2750-4)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.



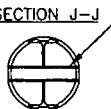
DETAIL G



SECTION H-H



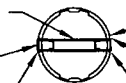
SECTION J-J



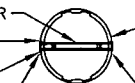
**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

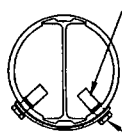
SECTION T-T



SECTION U-U



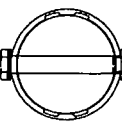
DETAIL K



USE AN3C7A BOLTS  
FOR INSTALLING ART  
D2648-3 WEARPAD  
(4 PLACES)

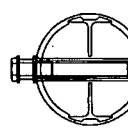
AN3C5A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(38 PLACES)

DETAIL P



AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

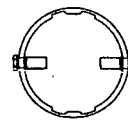
DETAIL M



AN6C44A BOLT (1)  
D2745 BUSHING (2)  
NAS1515H8L WASHER (2)  
MS21043-6 NUT (1)  
(4 PLACES)

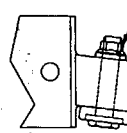
NOTE: INSTALL WASHER BETWEEN  
SKIDTUBE AND BUSHING

DETAIL Q



AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)

DETAIL N



AN8C21A BOLT (1)  
AN960JD816L WASHER (1)  
NAS1515H8L WASHER (1)  
MS21083C8 NUT (1)  
(2 PLACES)

**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

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